DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-027709
Date Inspected: 06-Jun-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1730
Location: Job Site

CWI Name:	Fred Michels			**CWI Present:**	☑ Yes	☐ No		
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A	
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A	
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A	
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A	

Bridge No: 34-0006
Component: SAS Tower

Summary of Items Observed:

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At Tower elevation 65 meter, QA randomly observed ABF/JV qualified Rory Hogan continuing to perform all position Shielded Metal Arc Welding (SMAW) fillet welding Crosby size number 4 padeye on tower skin plates. There were four padeyes being welded on tower skin plates A and E on tower shafts South and East while there are only two being welded padeyes on tower skin plate A of tower shafts North and West. The padeyes are also being welded per Contract Change Order (CCO) #201 and per Caltrans approved drawing Tower Access Detail #30.

Prior welding, ABF foreman Rory Hogan was noted laying out the location of the padeyes while another ABF personnel was noted grinding off the paint on the tower where the padeye will be welded. After grinding, the same personnel preheated the tower skin plate to required temperature of more than 225°F. After reaching the required preheat temperature, ABF welder Rory Hogan performed the tack welding using SMAW with 3.2mm diameter E7018H4R electrode with measured working current of 130 amperes on the mentioned electrode.

As soon as the padeye is tack welded, the welder immediately preheated the tower skin plate and the padeye itself to the required preheat temperature of more than 225°F. The welder then fully fillet welded the Crosby Padeye to 5mm all around fillet using the same electrode and size. During fillet welding, ABF QC Fred Michels was observed monitoring the preheat temperature and working current.

WELDING INSPECTION REPORT

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At the end of the shift, the welder has completed fillet welding a total of 12 padeyes at tower four shafts elevation 65 meters.

Summary of Conversations:

No significant conversation ocurred today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Lizardo,Joselito	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer